



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-742-043
Job Sheet 168764



Part No: D412-742-043

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/22/17

Job Tracking No:

Due Date: 12/8/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP
Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC
IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/17	0.00	0.00	Start Up Container		
110	HandFinish	1 pcs		12/8/17	0.00	3.50	HandFinish4		
120	QC	1 pcs		12/8/17	0.00	0.00	QC5		23
125	DC	1 pcs		12/8/17	0.00	0.00	DC		
130	Packaging	1 pcs		12/8/17	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		12/8/17	0.00	0.00	QC21		

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 _____ Expiry date: _____
2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/R Sikaflex-241/-291 _____ Expiry date: _____ 3-Remove "T" pins once sikaflex is dry.
4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon _____
VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY BY: _____ DATE: _____
125 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007
130 - Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3C4A 5000533	24	1,093	0	0
	AN3C6A FM137361-1	4	89	0	0
	AN5C7A 5002955	10	175	0	0
	D3391-021 5017282	1	1	0	0
	D3391-023 5022899	1	0	0	0
	D3391-025 5014091	1	7	0	0
	D4095-041 F159367	1	19	0	0
	D4095-043 5027145	1	13	0	0
	D4095-045 F154365	1	9	0	0
	NAS1149C0332R	28	3,419	0	0
	NAS1149C0532R	10	308	0	0
	5014735				
	FM138409-15				

Part Specifications

Specifications could not be found.

QA Closed: Date:



Work Order: _____

Part No. _____

NCR No. _____

Date :	Step #
--------	--------

Description	Work Order

Date	Time	Location	Weather	Wind	Temp	Humidity	Pressure	Remarks

Root Cause		
Environment		No Re-verification
Design		Operator
Doc/Data		Offset/Setup
Equip/Tooling		Supplier
Handling/Pre		Training
Material		Use for Testing
Internal Transport		Poor Information
Tribal Knowledge		Rushing
LOA		Product Improvement
Substation		Process Improvement
Past Expiry Date		Manufacturing Process
Misidentified		Past Due

	Pre	2/29/17 764
	Bei	
	Cer	
	Cra	
	Crir	
	Cuffs	
	Crushing	
	Heat Treat	
	Wave/Twist in Tube	
	Marks/Chatter	
OTHER :		

	Contamination
	Countersink
	Cut Too Short
	Instructions Incomplete/Unclear
	Drill Holes

IRY		IRY	
☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread
☐	Misaligned/off center	☐	Turning Sequence

Revision:
Operation:
Change No.:

Start up Operation
CHG007

Mfg Date: 12/29/17
Job No: 168764

Tri-Bag Float Comp.
PART NO: **D412-742-043**

Scidtuhe Eits LH or RH, High Gear, DART (Apical)

S027541

AEROSPACE
7EAT

ART

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Work Order update only

AINST DEPARTMENT/PROCESS

Water Jet	Engineering
Prod. Eng. Coord.	Quality
Rec/Store/Packaging	Other
Supplier	

MRB (QSI042) Approval

position

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

RY

	Power Loss/Surge		Positioned Wrong
	Folio/Program		Outside Dimensions
	Grain		Over/Under tolerance
	Weld		Part Incorrect
	Wrong Stock Pulled		Part Lost/Missing
	Out of Sequence		Part Moved
	Off-set		Drawing
	Mislabeled		Finish
	Fit/Function		Misread
	Misaligned/off center		Turning Sequence